



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D500-572-011
Job Sheet 194598



Part No: D500-572-011

Job Qty: 1 pcs

Part Name: MD369/MD500 Bearpaws



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/6/19

Job Tracking No:

Due Date: 5/31/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG IIND500-572 REV A, DSI 9770 REV A IPP Rev:C 04.02.17 Blank size changed KJ/JLM IPP Rev:D 07-01-02 Was K10007 JLM IPP Rev:E 08-01-09 Added Step 2 JLM Verified By:EC IPP Rev:F 08-10-15 New Manufacturing Method JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
160	Packaging 1 - Pick Kit	1 pcs	5/31/19	0.00	0.00		Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

DAS
28
9-89



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S180994



Part: D500-572-011

Job No: 194598

Serial No/Batch: S180994

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH90-17 Issue 7 of 7 FAA STC SH849NE

					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
170 QC 4	1 pcs	5/31/19	0.00 0.00		QC 4 - 28	
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	DAS
					QC 4 - 46	46 MAY 14 2019
					QC 4 - 68	9-89
180 Packaging 3-1 - Stock - B4B	1 pcs	5/31/19	0.00 0.00		Packaging 3 - 1 - B4B	DAS
					Packaging 3 - 2 - B4B	46 MAY 14 2019
					Packaging 3 - 3 - B4B	9-89
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
185 DC - 1 - B4B	1 pcs	5/31/19	0.00 0.00		DC - 1 - B4B	DAS
					DC - 2 - B4B	21 MAY 14 2019
190 QC 21 - FG	1 pcs	5/31/19	0.00 0.00		QC 21 - FG - 21	9-89
					QC 21 - FG - 70	DAS
					QC 21 - SA - 53	21 MAY 14 2019

Part Op 160 - Pick Kit

Descriptions: 170 - QC4- 100% Inspect kits for completeness

180 - Identify and pack for shipping as per PPPD500-572-011

185 - Document Control - Photocopy bluefile and create labels per PPP D500-572-011 CHG006

190 - QC21- Final Inspection - Work Order Release

009769

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-13A	Bolt	8 Ea (8 ea)	160-Packaging 1 - Pick Kit	5158578
D2274	Radius Block	8 pcs (8 ea)	160-Packaging 1 - Pick Kit	5155948
D2435	Bearpaw	2 pcs (2 ea)	160-Packaging 1 - Pick Kit	5163061
D2529	Washer	8 pcs (8 ea)	160-Packaging 1 - Pick Kit	5148345
D5472-1	Cushion	4 pcs (4 ea)	160-Packaging 1 - Pick Kit	F160782
D5476-1	Clamp	4 pcs (4 ea)	160-Packaging 1 - Pick Kit	5084783
MS21042L4	Nut	8 Ea (8 ea)	160-Packaging 1 - Pick Kit	5158232
NAS1149D0463J	Washer	8 Ea (8 ea)	160-Packaging 1 - Pick Kit	5158585
QS200-M44S	Clamp	2 Ea (2 ea)	160-Packaging 1 - Pick Kit	5100404

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
160-Packaging 1 - Pick Kit	AN4-13A	8	1,268	0
	D2274	8	18	0
	D2435	2	10	0
	D2529	8	603	0
	D5472-1	4	126	0
	D5476-1	4	4	0
	MS21042L4	8	3,333	0
	NAS1149D0463J	8	5,010	0
	QS200-M44S	2	22	0

Part Specifications

Specifications could not be found.

Plex 5/6/19 7:46 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D500-572-011 Bearpaw Installation	8.5 lb 3.86 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	130 in 3.30 m	1105 in-lb 12.74 m-kg
D500-572-021 Narrow Bearpaw Installation	7.5 lb 3.41 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	130 in 3.30 m	975 in-lb 11.25 m-kg
D500-572-013 Bearpaw Installation	11.4 lb 5.17 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	128 in 3.25 m	1459 in-lb 16.80 m-kg
D600-572-015 Bearpaw Installation	11.4 lb 5.17 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	122 in 3.10 m	1391 in-lb 16.03 m-kg

5. PARTS LIST

Qty D500 -572 -011	Qty D500 -572 -021	Qty D500 -572 -013	Qty D600 -572 -015	Part Number	Description
X				D500-572-011	BEARPAW INSTALLATION
	X			D500-572-021	NARROW BEARPAW INSTALLATION
		X		D500-572-013	BEARPAW INSTALLATION
			X	D600-572-015	BEARPAW INSTALLATION
2				D2435	BEARPAW
	2			D2671	BEARPAW
		2		D2995	BEARPAW
			2	D2996	BEARPAW
4	4	4		D2182B050	RUBBER CUSHION
			4	D2182B060	RUBBER CUSHION
8	8	8	8	D2274	RADIUS BLOCK
4	4	4		D2438	CLAMP
			4	D2519	CLAMP
8	8	8	8	D2529	WASHER
		8	8	AN4-13A	BOLT
8	8			AN4-15A	BOLT
8	8	8	8	AN960JD416	WASHER
8	8	8	8	MS21042L4	NUT (OR MS21042-4)
2	2			QS200M44S	CLAMP
			4	QS100M24S	CLAMP

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